



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.4002
Job Sheet 178396



Part No: 646.4002

Job Qty: 2 ea

Part Name: AS350 Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.07 DWG REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/13/18	6/13/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 01 2018
110	Packaging	2 pcs	6/13/18	6/13/18	0.00	0.00	Packaging1-1		JUN 01 2018
120	QC	2 pcs	6/13/18	6/13/18	0.00	0.00	QC4		21
130	Packaging	2 pcs	6/13/18	6/13/18	0.00	0.00	Packaging3-1		21
135	DC	2 pcs	6/13/18	6/13/18	0.00	0.00	DC		21
140	QC21-FG	2 Ea	6/13/18	6/13/18	0.00	0.00	QC21		21 18-06-13

Part Op 130 - Identify and pack for shipping as per PPP 646.4002 Location : FG102
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	2 pcs (1 ea)	90-Start up Operation	
646.3410	LH Wiper Deflector	2 Ea (1 ea)	90-Start up Operation	
646.3411	RH Wiper Deflector	2 Ea (1 ea)	90-Start up Operation	
646.3814	Wiper Bracket	4 Ea (2 ea)	90-Start up Operation	
MS21042L3	Nut	12 Ea (6 ea)	90-Start up Operation	
MS24694-S53	Screw	4 Ea (2 ea)	90-Start up Operation	
MS27039-1-18	Screw	4 Ea (2 ea)	90-Start up Operation	
MS27039-1-19	Screw	4 Ea (2 ea)	90-Start up Operation	
NAS1149F0332P	Washer	32 Ea (16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	2	18	0
	646.3410	2	8	0
	646.3411	2	8	0
	646.3814	4	20	0
	MS21042L3	12	1,451	0
	MS24694-S53	4	229	0
	MS27039-1-18	4	1,301	0
	MS27039-1-19	4	415	0
	NAS1149F0332P	32	2,119	0

3596

Part Specifications
Specifications could not be found.

Plex 5/31/18 7:49 AM dart.lacelle.linda



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CANADA
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Container No: S077090



Part: 646.4002

Job No: 178396

Serial No/Batch: S077090

Revision:

Inspector:

Exp Date: 06/01/2018

Instructions:

Date: 06/01/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
0119 003596	S077071	600.1012	Sealant PR1425B2 (#654 sem)	S075327	CCK017	2
003596	F125082-10	646.3410	LH Wiper Deflector		CCK010	1
003596	S032533	646.3411	RH Wiper Deflector	S032532	CCK010	1
003596	S077072	MS21042L3	Nut	S075328	ST303	12
003596	S077073	MS24694-S53	Screw	F113359	ST284	4
003596	S077074	MS27039-1-18	Screw	F124326	OVER006	4
003596	S077075	MS27039-1-19	Screw	S065263	ST280	4
003596	S077076	NAS1149F0332P	Washer	S068663	ST262	32

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/1/18 9:31 AM dart.quirion.sonia

646 3814 x2 S070335

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NOTES:

△ AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

△ INSTALL F/N 14 WITH F/N 52 & 53.

A △ 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMMASTER-CARR P/N 75935A651.

△ 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

△ REUSE FASTENERS FROM F/N 1.

△ USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

△ AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

△ INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT, REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

B △ NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	7B	601.3875	SCREW	MECHANICAL				
1	1	1	77	646.9410	SHIM	△				
	4	4	76	601.2764	WASHER	NA5118PMB2P				
	2	2	75	601.2973	LOCKNUT	MS21042-08				
	2	2	74	601.2988	SCREW	MS27039-0813				
	2	2	73	601.2943	LOCKNUT	MS21042-05				
	2	2	72	601.3128	NUT	AN316C4R				
	2	2	71	601.3209	LOCKNUT	MS21042-04				
	4	4	70	601.2638	WASHER	NA5118PMB2P				
	2	2	69	601.2669	BOLT	AN447A				
	2	2	68	601.3119	CLEVIS	AN665-34R				
	2	2	67	601.3121	EYE BOLT	AN444-SA				
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT	△				
		2	64	601.3151	WASHER	NA5118PMB2P				
			63	601.2911	SCREW	MS24694553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PR-1455 CLASS B				
	1	1	53	600.0991	MAGNOBOND 6398 PART B	△				
	1	1	52	600.0990	MAGNOBOND 6398 PART A	△				
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-16				
2		2	48	601.1365	SCREW	MS27039-1-10				
2		2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
1		1	45	646.3717	DOUBLER					
	22	22	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02199, 02381, 02718 & 02765	03/08/2010	P. BRAVO
B	INCORPORATED ECN 02046, 02079 & 04121	11/04/2014	P. BRAVO
C	INCORPORATED ECN 03098	06/29/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS24694554			
		2	2	40	601.2831	RIVET	MS20426AD5-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2		2	37	646.3715	STRUT DOUBLER				
		2	2	36	601.2824	BOLT	AN3-5A			
12	36		36	35	601.2277	RIVET	CR26488-3-07			
6	18		18	34	600.0795	NUTPLATE	MS21047-3			
3	3		3	33	601.2565	RIVET	MS20470AD5-7			
1	1		1	32	646.3813	STRUT BRACKET				
4	4		4	31	601.2822	BOLT	AN3-3A			
2	2		2	30	646.3812	GUSSET BRACKET				
8	8		8	29	601.2564	RIVET	MS20470AD5-6			
1	1		1	28	646.3714	GUSSET				
	1	1	1	27	646.3610	FILLER				
	3	3	3	26	601.2830	SCREW	MS24694555			
	2	2	2	25	601.2825	BOLT	AN3-5A			
	1	1	1	24	646.3811	RADIUS BLOCK				
	1	1	1	23	646.3712	CLIP				
	1	1	1	22	646.3711	CLIP				
8	8		8	21	601.2832	RIVET	MS20470AD5-5			
14	14		14	20	601.2020	RIVET	CR2315-5-3			
4	6	4	6	10	601.2823	BOLT	AN3-4A			
	1	1	1	18	601.2827	BOLT	AN3-13A			
	5	5	5	17	601.2912	SCREW	MS24694551			
	1	1	1	16	646.3713	GUSSET				
	1	1	1	15	646.3210	SUPPORT				
		1	1	14	646.3710	DOUBLER				
		1	1	13	646.3110	CHANNEL				
14	10	8	53	61	601.1624	LOCKNUT	MS21042-3			
16	32	18	120	16	601.1607	WASHER	NA5118PMB2P			
				10	646.3410	LH WIPER DEFLECTOR				
				9	646.3411	RH WIPER DEFLECTOR				
		2	2	8	647.7703	STRUT ASSY				
		2	2	7	647.0112	STRUT BRACKET				
	1	1	1	6	646.3511	STRUT				
	1	1	1	5	646.3510	STRUT				
2		2		4	646.3810	BRACKET				
		1	1	3	646.2910	DEFLECTOR				
	1	1	1	2	646.3001	LOWER CUTTER ASSY				
		1	1	1	646.3301	UPPER CUTTER ASSY				
X					646.4006	LOWER CUTTER FIXED PROVISIONS				
	X				646.4005	LOWER CUTTER REMOVABLE PROVISIONS				
		X			646.4004	FIXED PROVISIONS KIT				
			X		646.4003	CABLE CUTTERS KIT WITHOUT FIBER PROVISIONS				
				X	646.4002	AS350 WIPER DEFLECTOR KIT				
				X	646.4001	AS350 CABLE CUTTERS KIT				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE: 08-27-06	
		DRAWN BY: J. CECIL	
		1. HUF	
		DESIGNED BY: P. BRAVO	
		P. BRAVO	
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED:	
		DIMENSIONS ARE IN INCHES	
		TOLERANCES ARE:	
		3 PLACES DECIMALS: .000	
		2 PLACES DECIMALS: .00	
		1 PLACE DECIMAL: .0	
		ANGLES: 1/2°	
		SHEET: 07M16	
		DWG. NO: 646.4000	
		SCALE: NONE	
		SHEET: 1 OF 5	

DART 3030 ENTERPRISE CT.
SUITE A
VISTA, CA. 92081
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APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

AS350 CABLE CUTTERS KIT